

Date: Wednesday, 10/10/2007 11:04:43 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : END CAP
Job Number : 35095	
Estimate Number : 11877	
P.O. Number :	Part Number : D2208
This Issue : 10/10/2007 S.O. No. :	Drawing Number : D2208 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 33239	Material :
Written By : <u> </u>	Due Date : 10/31/2007 Qty: 20 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est A 01.03.08 New Issue	
Est B 07.09.11 ecn 998 EC verified by: JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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3.5213



Comment: Qty.: 0.1531 sf(s)/Unit Total : 3.0618 sf(s)
 6061-T6 .063 Sheet
 5052-H32 or 6061-T6 - .063" Thick
 Batch M19326 IB 07-10-12

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2208
 Dwg Rev: C IB 07-10-12
 Prog Rev: C

(23)

2-Deburr if necessary IB 07-10-12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 07-10-12



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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counter

Comment: SECOND CHECK

IB 07-10-12 (23)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location:

IB 07-10-12 (23)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END CAP

Job Number: 35095

Part Number: D2208

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



07.10.16 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



[Signature] 07.10.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

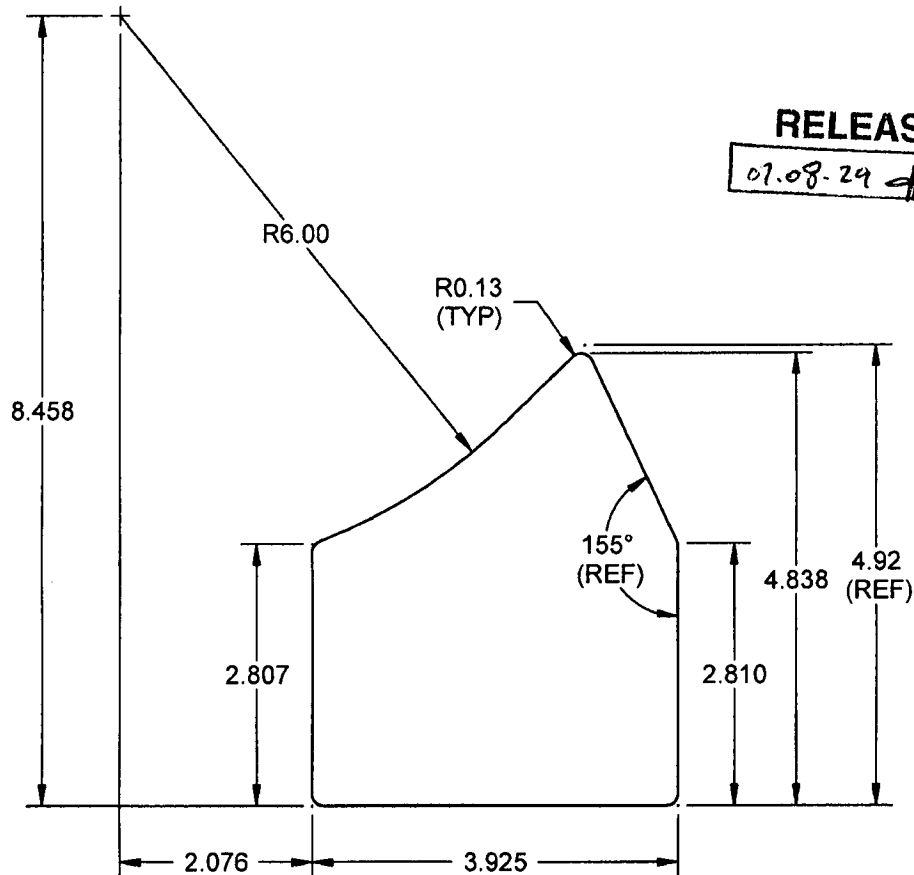
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2208	REV. C SHEET 1 OF 1
DATE 07.07.05		TITLE END CAP	SCALE 1:2
REV	DATE	DESCRIPTION	
A	94.09.01	NEW ISSUE	
B	01.02.22	REDRAWN	
C	07.07.05	REDESIGN	

**RELEASED**07.08.29 *[Signature]***D2208 END CAP****NOTES:**

1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK) PER AMS-QQ-A-250/8 OR AMS 4016 (REF. DART SPEC. M5052H32S.063) OR 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK) PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **35095**

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